

Work Order ID 69954

Wednesday, May 25, 2011 8:08:45 AM



Page 1

Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-642	Rev N								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

5/16/17

for CL 11-6-16

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/6/17 SP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/16/17



B69664

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69954

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Page 2

Item ID: D206-642-311BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube LH

Start Date: 5/24/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 1.00

Customer:



Reference:

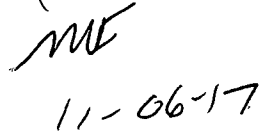
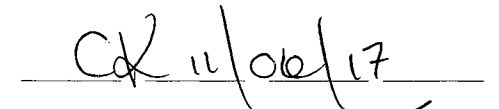
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311 Location: _____ PPP Rev: <u>F</u>								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:52 AM

Page 1

Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

1



Replacement Skidtube

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

Manufactured

No

110

Each

10.0000

1

1



GHW Modification

Location

Loc Qty

Loc Code

FG120

10

67596

6

68347

4

ATTN: D3414-041 - BLUE

D2932-1

Manufactured

No

110

Each

4.0000

1

1



Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST421

2

67259

2

ST428

2

67790

2

BLUE

69669

70889

11617.50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 2

Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-1

Manufactured No

110

Each

4.0000

1



Saddle LH In, 206



SP

Location

Loc Qty

Loc Code

ST421

4

67260

4

BLUE

D2938-1

Manufactured No

110

Each

4.0000

1



Saddle LH Out, 206



SP

Location

Loc Qty

Loc Code

ST421

4

67261

4

BLUE

D2939-1

Manufactured No

110

Each

5.0000

1



Saddle LH In, 206



1
m/16/178

Location

Loc Qty

Loc Code

ST421

3

67262

3

ST428A

2

67674

2

BLUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Picklist Print

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Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

8 AN3-41A
Bolt

Purchased No

110 Each

323.0000

8 8

Location

Loc Qty

Loc Code

ST354

323

112431

1

115936

72

116191

200

117794

50

Manufactured No

110 Each

424.0000

16 16

8 D2652
Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

380

67756

180

68941

200

Purchased No

110 Each

2,178.000

8 8

MS21042L3
Nut

Location

Loc Qty

Loc Code

ST300

2178

116391

11

116540

201

116549

766

117441

800

117601

400

Purchased No

110 Each

0.0000

8 8

AN960JD10
Washer

NAS1149D0363J

1117291

1116117

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Picklist Print

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Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

304.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST337

304

117313

179

117795

125

4

AN5-11A

Purchased

No

110

Each

92.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST337

92

117313

92

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

8

8



Washer

AN4-6A

Purchased

No

110

Each

1,099.000

12

12



Bolt

Location

Loc Qty

Loc Code

ST356

899

115936

99

116400

400

116924

400

ST358

200

117514

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

25

25



Washer

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased No

110 Each

4,682.000

12 12



Nut

Location

Loc Qty

Loc Code

ST300

4682

116823

882

117441

3000

~~117601~~

800

D3407-043

Manufactured No

110 Each

19.0000

1



Tow Ring

Location

Loc Qty

Loc Code

ST420

2

~~66386~~

2

ST464

17

64071

7

68339

10

BLUE

D3456-1

Manufactured No

110 Each

71.0000

1



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

64

63239

4

66848

6

68748

54

Wednesday, May 25, 2011 8:08:53 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Picklist Print

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Page 6

Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110 Each

40.0000

2

2



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

30

67779

30

MS21043-4

Purchased No

110 Each

1,670.000

1

1



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

576

117423

576

ST301

1054

115936

40

116549

14

117601

500

117793

500

AN4C5A

Purchased No

110 Each

530.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP-B

115

112243

115

ST345

415

112243

415

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, May 25, 2011 8:08:54 AM

Page 7

Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No

110 Each

0.0000

1



washer

D3413-1

Manufactured No

110 Each

34.0000

1



Ring

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

15

65294

1

66945

14

BLUE

D2712

Manufactured No

110 Each

451.0000

10



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

M117735 SP

SP

10/16/11 SP

10

Wednesday, May 25, 2011 8:08:54 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:08:54 AM

Page 8

Work Order ID: 69954

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2934

Manufactured No

110

Each

38.0000

2

2



Saddle Spacer



sl

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

Manufactured No

110

Each

55.0000

2

2

D2935



Saddle Spacer



2
11/6/17 sl

Location

Loc Qty

Loc Code

ST027

56

66564

56

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N
Date: 09.09.09